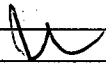
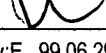


Date: Monday, 22/01/2007 1:54:55 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SCUFF PLATE
Job Number : 30264	
Estimate Number : 10825	
P.O. Number : N/A	Part Number : D206555004
This Issue : 22/01/2007 S.O. No. : N/A	Drawing Number : D206-555 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 30264	Material : N/A
Written By : 	Due Date : 29/01/2007 Qty: 10 Um: Each
Checked & Approved By : 	
Comment : Est Rev:E 99.06.29 Returned to Electro Polish DM Est Rev:F Now On Waterjet 07-01-22 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL
Type Labels as per PPP D206-555-004

2.0	M304S25GA	304/316 .020" Sheet
-----	-----------	---------------------



Comment: Qty.: 0.4610 sf(s)/Unit Total : 4.6100 sf(s)
304/316 .020" Sheet
Batch: ml 102393 ml 07 01 23 (10)

3.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D206-555
Dwg Rev: C
Prog Rev: C ml 07 01 23 10

2-Deburr if necessary SB John 07/02/08 (10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE ml 07 01 23 (10)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK 07/01/23 (10)

Date: Monday, 22/01/2007 1:54:55 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 30264

Part Number: D206555004

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form parts on hydraulic press as per Dwg. D206-555 using DT 8316-4

2-Finish form on bench forming Jig DT 8317-4

SAB 07/02/12 (10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20702.14 (10)

8.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting Outside services

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.

Issue P/O: 3137

Possible supplier: TQF Technologies

CD 07/02/12 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

07/02/12 (10) 07/2/12 (10)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove tooling tabs and deburr

updated by
07-01-22

NIA

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20702.27

Date: Monday, 22/01/2007 1:54:55 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 30264

Part Number: D206555004

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

6/7/05 *FO*

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10
07/03/05

Job Completion



U 40305

Date: Tuesday, 1/16/2007 11:12:05 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SCUFF PLATE
Job Number : 30264	
Estimate Number : 10825	
P.O. Number :	Part Number : D206555004
This Issue : 1/16/2007 S.O. No. :	Drawing Number : D206-555 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : C
Previous Run : 24817	Material :
Written By :	Due Date : 2/10/2007 Qty: 10 Um: Each
Checked & Approved By :	
Comment : Est Rev:E 99.06.29 Returned to Electro Polish DM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL
 Type Labels as per PPP D206-555-004

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING
 Issue P/O: _____
 Email or ship DXF file to vendor Laser cut part as per DXF file
 Material release note required

3.0	D206555004F	SCUFF PLATE FLAT
-----	-------------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 SCUFF PLATE FLAT

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

5.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/16/2007 11:12:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 30264

Part Number: D206555004

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form parts on hydraulic press as per Dwg. D206-555using DT 8316-4

2-Finish form on bench forming Jig DT 8317-4

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting Outside services

Electrochemically polish per ASTM B912,High shine finish,No scratches on surfaces.

Issue P/O: _____

Possible supplier:TQF Technologies

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove tooling tabs and deburr

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/16/2007 11:12:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 30264

Part Number: D206555004

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



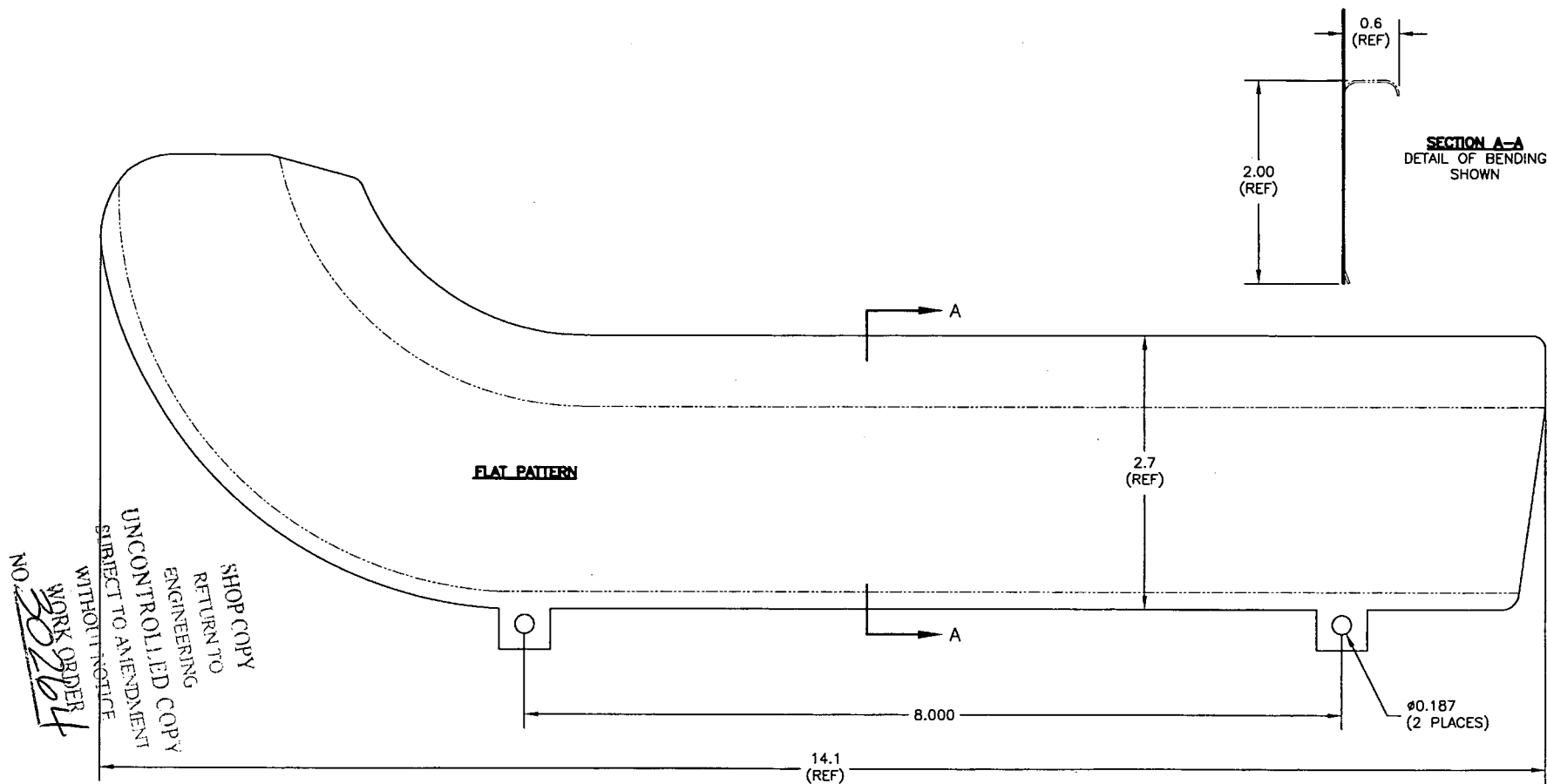
DESIGN JB	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	REV. C SHEET 1 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE NTS
A	89.06.08	NEW ISSUE	
B	98.10.26	RE-DRAWN ADDED D206-555-011/-012/-045	
C	06.09.01	REVISED FINISH PER NCR 016	

QTY REQUIRED			PART NO.	DESCRIPTION
-041	-043	-045		
X			D206-555-041	SCUFF PLATE KIT 206 A/B
	X		D206-555-043	SCUFF PLATE KIT 206 L/L1/L3
		X	D206-555-045	SCUFF PLATE KIT 206 L/L1/L3, EXECUTIVE INTERIOR
1			D206-555-001	FORWARD LH
1			D206-555-002	FORWARD RH
1			D206-555-003	AFT LH
1			D206-555-004	AFT RH
	1		D206-555-005	FORWARD LH
	1		D206-555-006	FORWARD RH
	1	1	D206-555-007	AFT LH
	1	1	D206-555-009	AFT RH
		1	D206-555-011	FORWARD LH
		1	D206-555-012	FORWARD RH

SHOP COPY
RETURN TO
RELEASED
06.09.01
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *30264*

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NO. 30264
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

D206-555-001 (BEND IN DIRECTION SHOWN IN SECTION A-A)
D206-555-002 (BEND OPPOSITE)

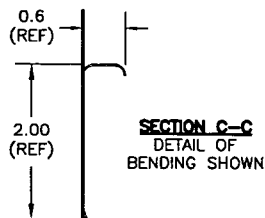
NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T1
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

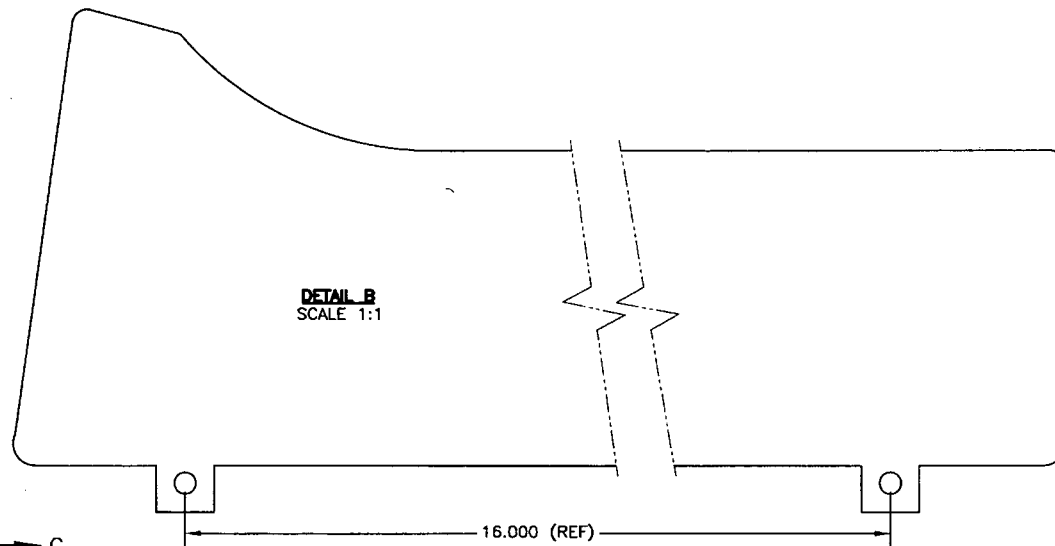
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06.09.19

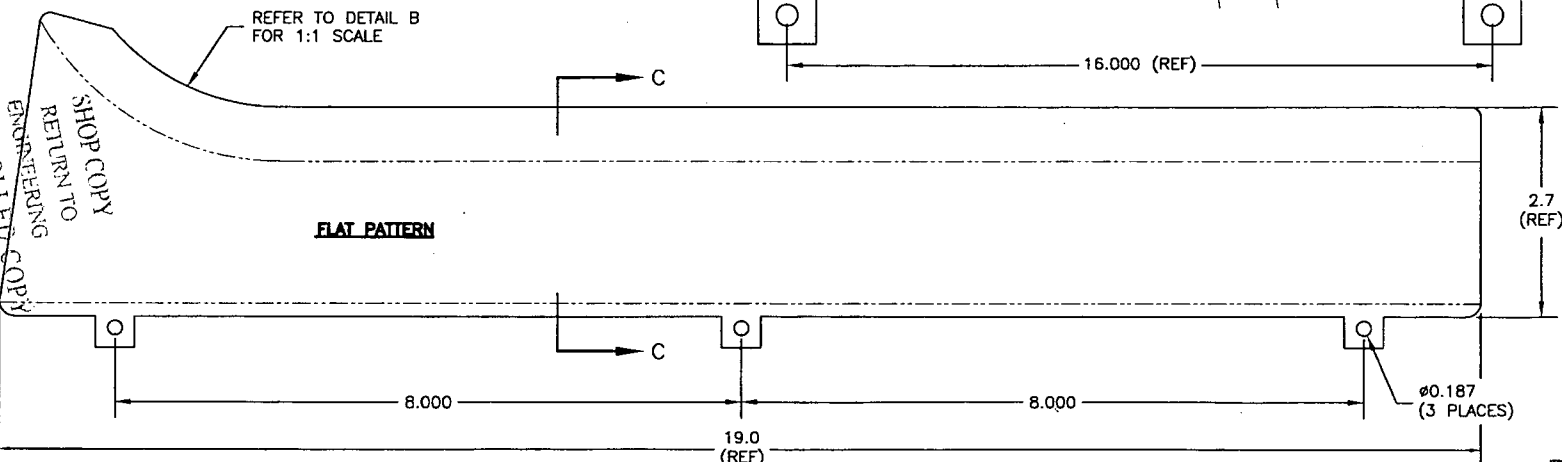
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CHECKED PH	APPROVED PH	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 2 OF 7 SCALE 1:1



DETAIL B
SCALE 1:1



REFER TO DETAIL B
FOR 1:1 SCALE



NO. 20264
UNCONTROLLED COPY
SHOP COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

RELEASED

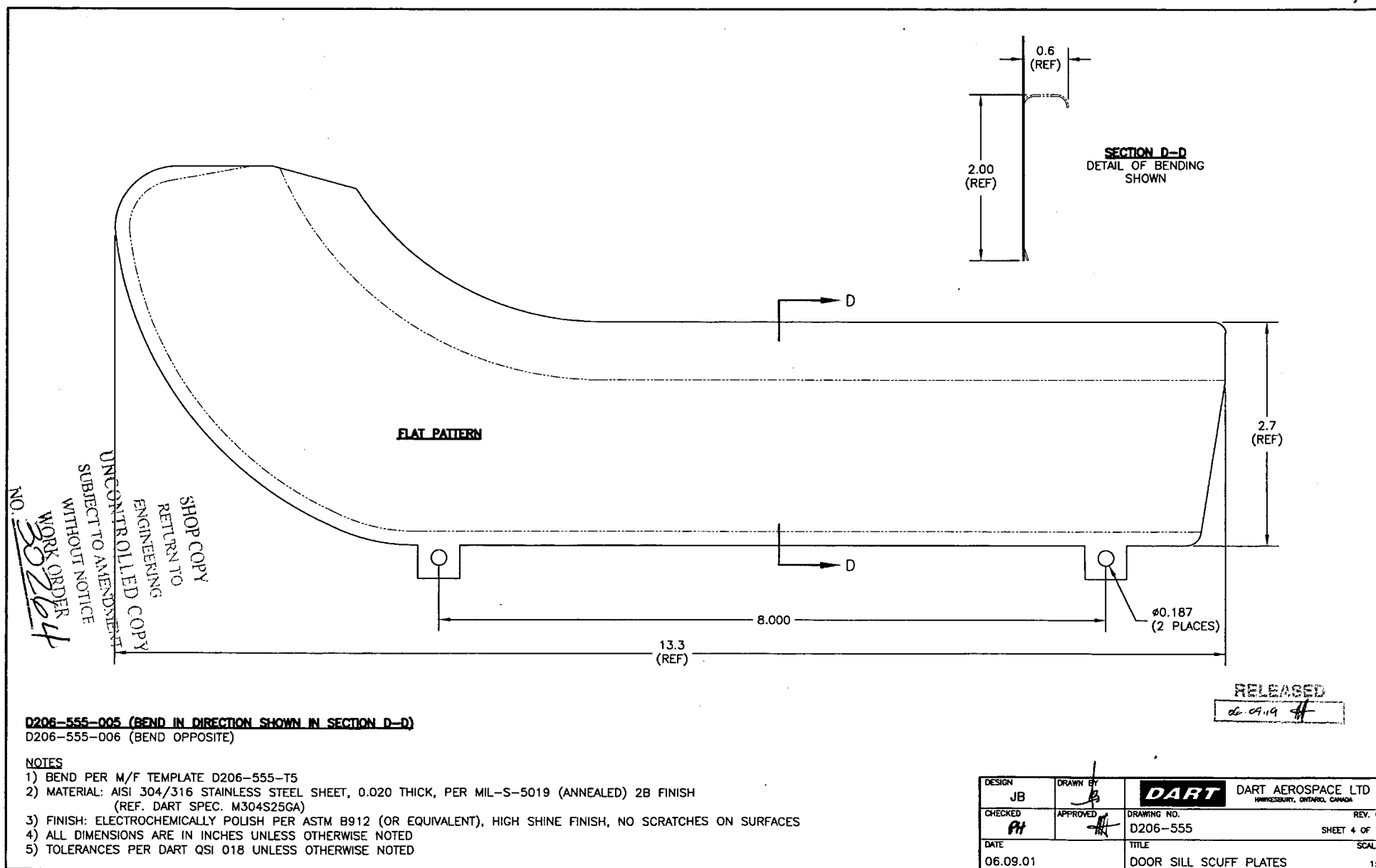
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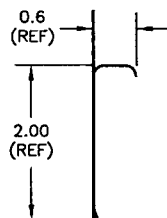
D206-555-003 (BEND IN DIRECTION SHOWN IN SECTION C-C)
D206-555-004 (BEND OPPOSITE)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T3
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

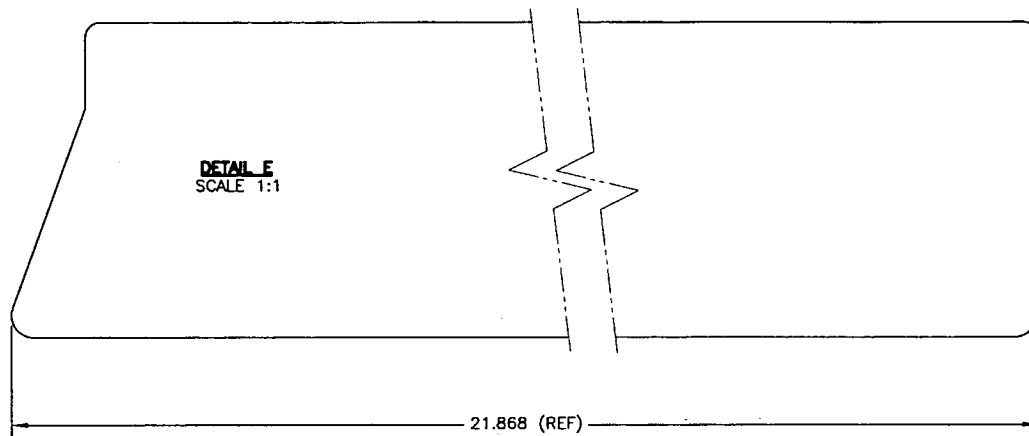
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CHECKED PH	APPROVED PH	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 3 OF 7 SCALE 2:3





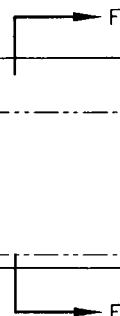
SECTION F-F
DETAIL OF
BENDING SHOWN

DETAIL E
SCALE 1:1



REFER TO DETAIL E
FOR 1:1 SCALE

NO. 30264
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
SHOP COPY
RETURN TO
ENGINEERING
FLAT PATTERN



2.7
(REF)

RELEASED

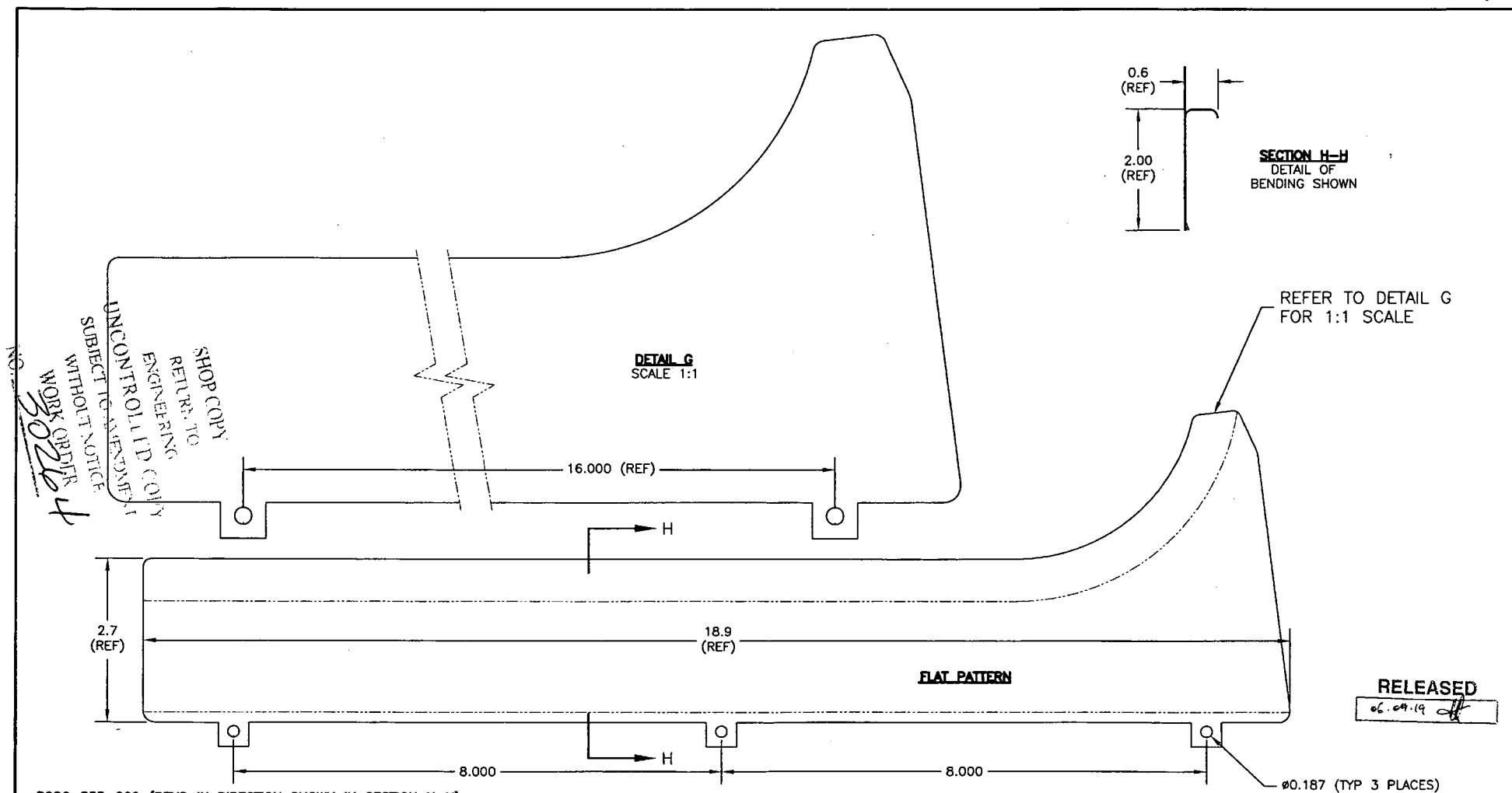
06.09.19

D206-555-007 (BEND IN DIRECTION SHOWN IN SECTION F-F)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T7
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY <i>[Signature]</i>	DART DART AEROSPACE LTD WILLOWDALE, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	REV. C SHEET 5 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES		SCALE 2:3

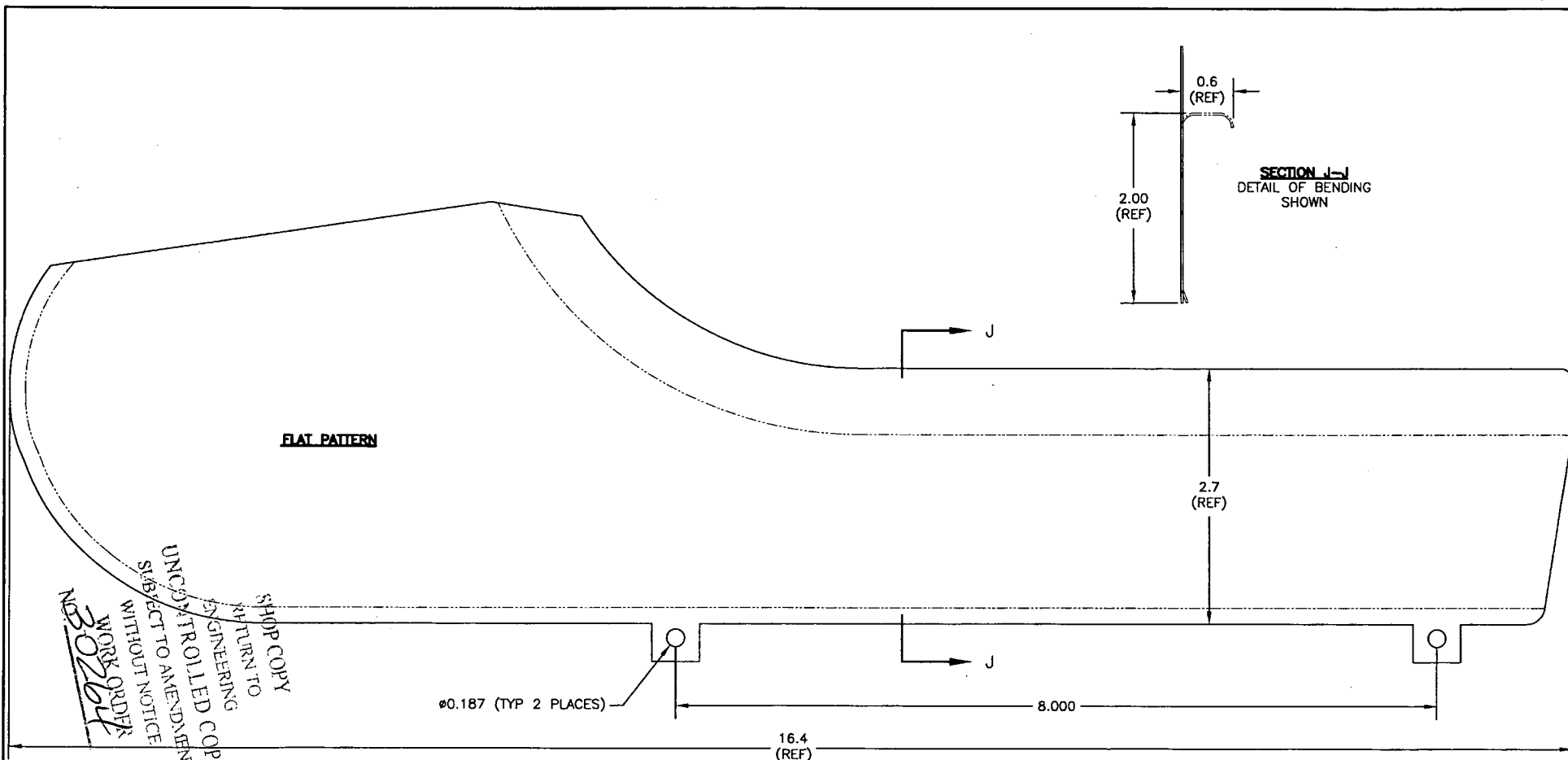


D206-555-009 (BEND IN DIRECTION SHOWN IN SECTION H-H)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T9
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	DART DART AEROSPACE LTD WILLOWDALE, ONTARIO, CANADA
CHECKED AT	APPROVED AT	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 6 OF 7 SCALE 2:3



D206-555-011 (BEND IN DIRECTION SHOWN IN SECTION J-J)
D206-555-012 (BEND OPPOSITE)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T11
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

06-09-01

DESIGN JB	DRAWN BY [Signature]	DART DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 7 OF 7 SCALE 1:1



Certificat de Conformité / Certificate of Compliance

A/TO: Dart Aerospace Ltd.

Date: February 26, 2007

1270 Aberdeen St

Hawkesbury, Ontario

No. de certificat
Certification No.

K6A 1K7

tel.: (613) 632-5200

fax: (613) 632-1053

C113178

bon de T. Job No.	Qt	# de pièce / Part #	Remarques / Remarks
124109	10	NO. DE COM./P.O.# 3137 D206-555-004 B30264	ELECTROPOLISH PER ASTM B912 REV.02 ✓

Nous certifions que les parties listées ci-dessus ont été faites et inspectées en conformité avec votre bon de commande, vos dessins et spécifications et sont en accord avec les exigences ci-inclus.

We hereby certify that the parts listed above have been processed and inspected in accordance with your purchase order, drawings and specifications, and are correct with regard to the requirements contained therein.

Signé pour et au nom de TQF Technologies Inc.
Signed for and on behalf of TQF Technologies Inc.

Raj Thakoordeen

#R 674

Initiator: Jean Kerr
Company: Rotor Components (Helicopter)
CR0101

Date: Nov. 30/07

Invoice # 4683
Order Entry # 4202

Phone No. 011 618 9414 1114

Attach Copy of DHS Return Authorization # 341

Reason for return: Extremely BAD quality.

~~Costana doe~~

Receiving:

Date Received: 8/2/18 Freight Company: Fresh

Prepaid	Collect
---------	---------

#	Part #	Batch #	Description	Distribute to QC	
				Advise QA	Date:
1	D206-555-001	2008	SCUFF DATE Fwd LH		
1	D206-555-002	25499	" " RH		
1	D206-555-003	31604	SCUFF DATE Aft LH		
1	D206-555-004	30064	" " RH		




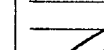
Condition of packaging: Good Photograph required: yes ☐ no ☒

Paperwork attached: P/S X Invoice 0 ARC _____ Docs _____ Other _____

QC:

Quarantine: _____ Location: Condition of Part: good

Inspect: Initial:

#	Part #	Batch #	QC Comments	QC Approval		Scrap
				Initial	W/O #	
1	D206-555-001	B26008	Return to stock as per W/O'S → Scrap & destroy as per W.O.		37671	
1	D206-555-002	B25499			37672	
1	D206-555-003	B31604			37675	
1	D206-555-004	B30264			37676	

QA Coordinator:

Advise GM as to findings: Initial: _____ Date: _____

Comments:

Issue credit: yes no

GM Approval: _____ Date: _____

Invoice Amount: _____
Less Replacement: _____
Restock Fee: _____
Freight: _____
Net Credit: _____
DHS ☐ Customer ☐

QA: Enter into Q-Pulse with reason for return & File original. Signed: _____ Date: _____

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit